

Work Order ID 103670

103670

Page 1

June-24-13 2:11:37 PM

Item ID: D3212-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Interior Window for -015 & -025

Start Date: 6/24/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 7/05/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-06-25 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3212 | C |

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut blankas per Dwg D3212 Dwg Rev: C Prog Rev: e

2-Deburr if necessary

2 0 Im13-0627

110

0.00

110

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA349 and Dwg D3212

SL
MH B/10/27

2 0 _____

120

0.00

120

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

SL
MH B/10/27

2 0 _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|--|--|--|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 103670

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Page 2

June 24-13 2:11:37 PM

Item ID: D3212-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Interior Window for -015 & -025
 Start Date: 6/24/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/05/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 2 | 10 | | |
| Quality Control | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | Small Fab | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | 2 | | | 13/10/31 |
| Small Fab | 1-Deburr if necessary 2-Install label as per Dwg D32123- polish abrasion scratches if necessary.. 4-Wrap in plastic wrap after inspection | | | | | | | | |
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 2 | | | |
| Quality Control | | | | | | | | | |

DAS
36
9-89

DAS
27
9-89

131031

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 103670

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Item ID: D3212-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Interior Window for -015 & -025
 Start Date: 6/24/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/05/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|-------------------|------------------|----------------|
| 160 | Identify as per dwg & Stock Location: <u>ST210</u> | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 2x | DAS 28 9-89 | 13-10-31 | |
| Packaging | | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

[Handwritten Signature] / 12-11-05
 ME
 13-10-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Picklist Print

June-24-13 2:11:37 PM

Page 1

Work Order ID: 103670

Parent Item: D3212-1

Parent Item Name: Replacement Interior Window for -015 & -025

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-09 JLM
 IPP Rev: B Water jet/ ecn798 06-05-08 EC
 IPP rev.C back on haas 07.04.09 EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|----------------|---------------|----------------|--------|
| MACRLICS.125 1/8" Polycast II Sheet | | Purchased | No | | | 140 | sf | 728.3445 | 0.9745 | 2.051579 25 | | Jm, 3-06-27. | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | MAT | | 275 | | | | | | | |
| | | | | m125767 | | 275 | | | | | | | |
| | | | | MAT019 | | 173.6 | | | | | | | |
| | | | | 123704 | | 33 | | | | | | | |
| | | | | 123949 | | 71 | | | | 123949 | | | |
| | | | | 124559 | | 69.6 | | | | | | | |
| | | | | ther | | 279.7445 | | | | | | | |
| | | | | 123895 | | 279.7445 | | | | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

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|--|--|---|---|

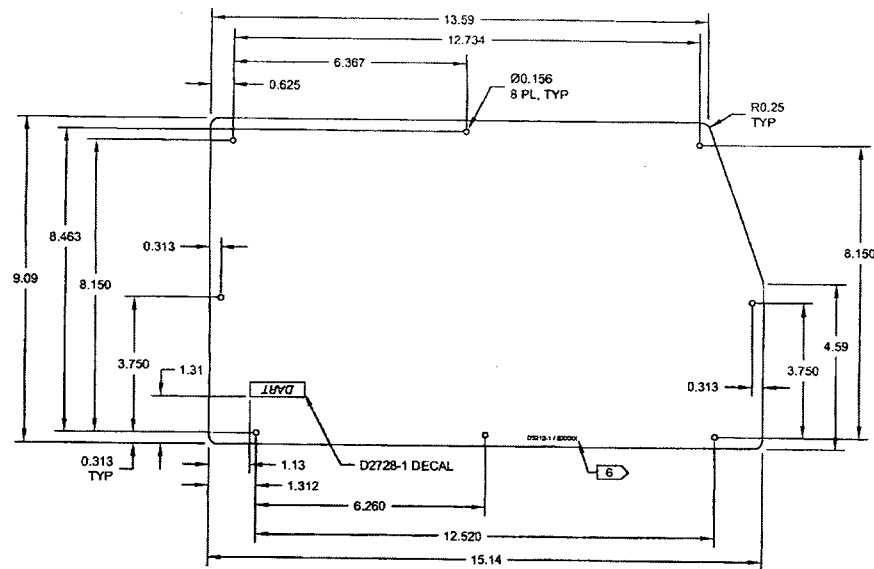
| | | | |
|----------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 103670 |
| Description: Floor Window | | Part Number: | D3212-1 |
| Inspection Dwg: D3212 | Rev: C | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

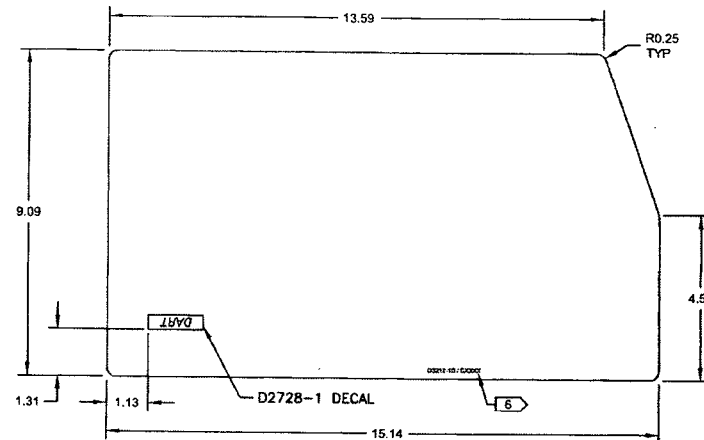
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 12.734 | +/-0.005 | 12.734 | ✓ | | | |
| 6.367 | +/-0.005 | 6.368 | ✓ | | CNC-02 | Caliper |
| 0.625 | +/-0.005 | .628 | ✓ | | MH-04 | Caliper |
| Ø0.156 | +0.005/-0.001 | .157 | ✓ | | MH-04 | Caliper |
| R0.25 | +/-0.030 | .25 | ✓ | | rad gauge | |
| 8.150 | +/-0.005 | 8.149 | ✓ | | 31006 | |
| 3.750 | +/-0.005 | 3.748 | ✓ | | 31006 | |
| 0.313 | +/-0.010 | .313 | ✓ | | MH-04 | |
| 15.14 | +/-0.030 | 15.146 | ✓ | | 31006 | |
| 12.520 | +/-0.005 | 12.519 | ✓ | | 31006 | |
| 6.260 | +/-0.005 | 6.260 | ✓ | | vern | CNC-02 |
| 1.312 | +/-0.005 | 1.314 | ✓ | | MH-04 | |
| 0.313 | +/-0.010 | .315 | ✓ | | MH-04 | |
| 3.750 | +/-0.005 | 3.7425 | ✓ | | 31006 | |
| 8.150 | +/-0.005 | 8.1475 | ✓ | | 31006 | |
| 8.462 | +/-0.005 | 8.463 | ✓ | | 31006 | |
| 9.09 | +/-0.030 | 9.09 | ✓ | | 31006 | |
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|-----------------------------|--------------------------------|------------------------------|
| Measured by: MH / SL | Audited by: [Signature] | Preliminary Approval: |
| Date: 13/10/27 | Date: 13/10/28 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------------|------------|-------------|
| A | 03.12.15 | New Issue P/O D350-567-015/-025/-031 | KJ/RF | |
| B | 07.05.28 | Dimensions updated per Dwg Rev. B | KJ/JLM | |
| C | 12.02.01 | Dwg Rev updated | KJ | [Signature] |



D3212-1 FLOOR WINDOW



D3212-1B BLANK FLOOR WINDOW

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M-ACRYLIC-S.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3212-X" AND B/N "BXXXXX" PER QSI 044 6.4 WITHIN 0.50 FROM EDGE
- 7) WEIGHT: 0.72 lbs
- 8) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1

UNCLASSIFIED
SUBJECT TO
REVIEW
103670 MLC
13-06-25

RELEASED
2011-06-15
MP

| C | UPDATE TO CURRENT STD; ADD D3212-1B. REASON: PAR11-109. | MB | 11.06.03 |
|------------|--|-----|----------|
| B | UPDATE MATERIAL PER NCR 029 | SSH | 06.04.13 |
| A | NEW ISSUE | CP | 03.09.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.06.03 | | |

| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3212 | REV. C SHEET 1 OF 1 |
| TITLE FLOOR WINDOW | SCALE NIS |
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